

Work Order ID 63242

Tuesday, October 26, 2010 10:16:23 AM

Page 1

Item ID: D3200-1

Accept

Revision ID:

Item Name: Door Post Block

Start Date: 10/27/2010 Start Qty: 20.00

Required Date: 10/29/2010 Req'd Qty: 20.00

Reference:

Approvals:

Process Plan:

Date: 10-10-26

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
| D3200 | Rev A |

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blank: 2.700" x 2.700

M.A. 10/11/01

20

0

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine D3200-1 as per Folio FA337 and Dwg D3200-2-Debur

M.A. 10/11/01

20

0

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

M.A. 10/11/01

20

0

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries



Work Order ID 63242




Tuesday, October 26, 2010 10:16:23 AM



Page 2

Item ID: D3200-1 Accept  Setup Start 
Revision ID: Stop 
Item Name: Door Post Block
Start Date: 10/27/2010 Start Qty: 20.00  Cust Item ID:
Required Date: 10/29/2010 Req'd Qty: 20.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|----------------------|---------|-------------|--------------|---------------|---------------|------------------|---|
| 130  QC Quality Control | QC8- Inspect parts - second check Memo | 0.00 0.00 | | amk10/11/02 | | 20 | 0 | | |
| 140  Packaging Packaging | Identify as per dwg & Stock Location: 40 Memo | 0.00 0.00 | | | | | | | 10/11/02 S/Goo |
| 150  QC Quality Control | QC21- Final Inspection - Work Order Release Memo | 0.00 0.00 | | | | | | | ck 10/11/03 MF MF 10-11-02 |

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|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Tuesday, October 26, 2010 10:16:27 AM

Page 1

Work Order ID: 63242



Parent Item: D3200-1



Parent Item Name: Door Post Block



Start Date: 10/27/2010

Required Date: 10/29/2010

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev:A Removed from 9 Digit 06-01-25 JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|---|--------------|---------------|----------------|--------|
| MUHMWB10  | | Purchased | No | | | 100 | sf | 186.1060 | 0.05 | 1.052632 | | | |
| UHMW 1" Black | | | | | | | | |  | | | | |

Location

Loc Qty

Loc Code

MAT

186.106

✓ 114624

8.8

115325

15.506

115955

161.8

1.0526 sf.

M.A 10/11/10

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

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|-------------------------------------|---------------|---------------------------------|
| DART AEROSPACE LTD | | Work Order: <u>63242</u> |
| Description: Door Post Block | | Part Number: D3200-1 |
| Inspection Dwg: D3200 | Rev: A | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|------------------|------------------|--------|--------|----------------------|----------|
| Ø0.196 | +0.005 -0.000 | Ø0.199 | ✓ | | Vern | GA-01 |
| 0.405 x 100° | +/-0.010 | 0.408 x 100° | ✓ | | " | " |
| R0.100 | +/-0.010 | R0.100 | ✓ | | R.G | ref. |
| R0.130 | +/-0.010 | R0.125 | ✓ | | " | " |
| 1.630 | +/-0.005 | 1.630 | ✓ | | Vern | GA-01 |
| 0.440 | +/-0.030 | 0.436 | ✓ | | " | " |
| 2.500 | +/-0.010 | 2.502 | ✓ | | " | " |
| 1.845 | +/-0.010 | 1.843 | ✓ | | " | " |
| 0.015 - 0.050 | N/A | 0.025 | ✓ | | " | " |
| 1.000 | +/-0.010 | 1.000 | ✓ | | " | " |
| 1.620 | +/-0.005 | 1.620 | ✓ | | " | " |
| 2.500 | +/-0.030 | 2.502 | ✓ | | " | " |
| 0.750 | +/-0.030 | 0.752 | ✓ | | " | " |
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| Measured by: <u>B.A</u> | Audited by: <u>anf</u> | Prototype Approval: N/A |
| Date: <u>10/11/01</u> | Date: <u>10/11/02</u> | Date: N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------|-------------------------------------|-----------|
| A | 03.11.12 | New Issue | P/O D412-698-015 KJ/RF <u>af</u> | <u>af</u> |

| W/O: | | WORK ORDER CHANGES | | | | | |
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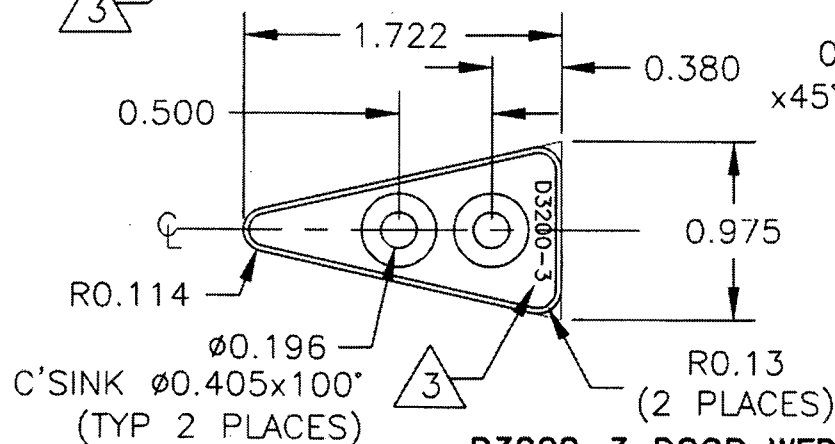
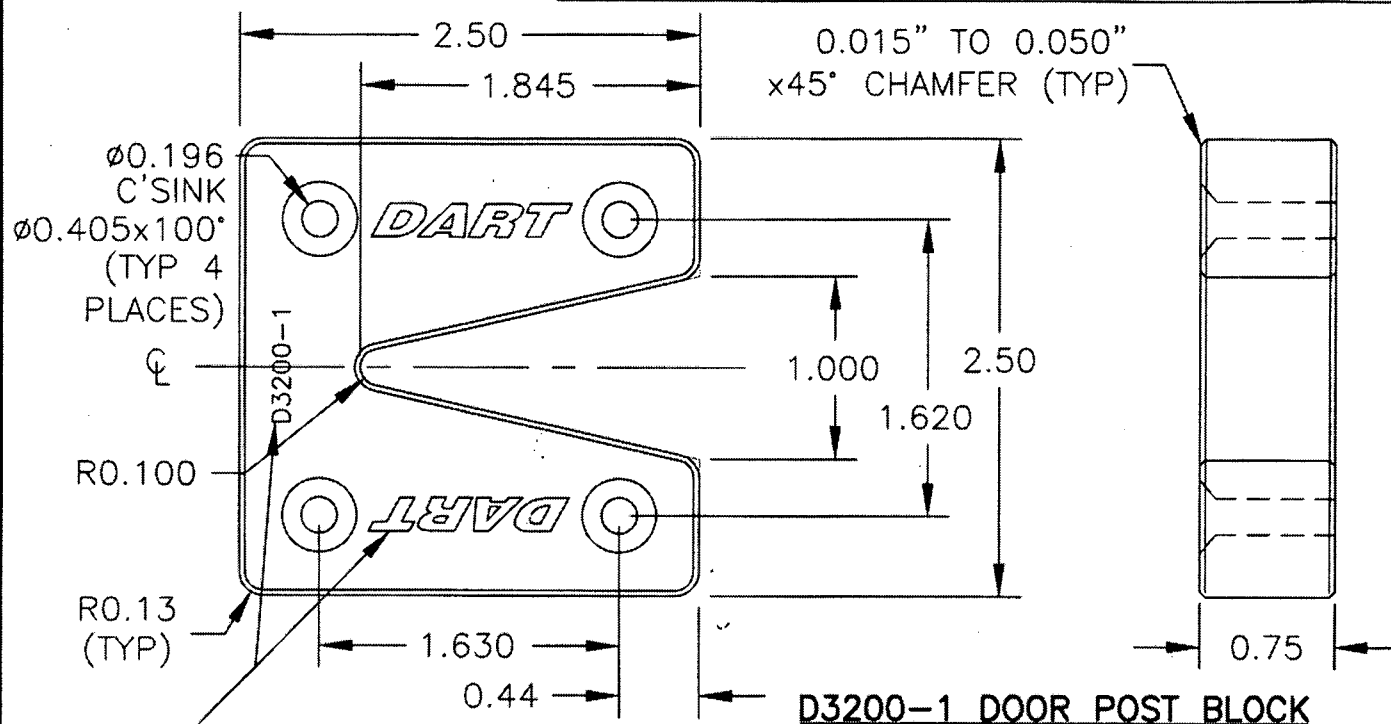
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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|---------------------|-----------------------|---|------------------------|
| DESIGN <i>UP</i> | DRAWN BY <i>UP</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>A</i> | APPROVED <i>A</i> | DRAWING NO. D3200 | REV. A SHEET 1 OF 1 |
| DATE 03.08.06 | | TITLE DOOR WEDGE | SCALE 1:1 |
| A | 03.08.06 | NEW ISSUE | |



D3200-3 DOOR WEDGE

D3200-1/-3

- 1) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
- 2) PARTS ARE SYMMETRIC ABOUT CENTERLINE
- 3) ENGRAVE DART LOGO AND P/N IN AREAS SHOWN
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
03.09.02

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *43242*

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